Ship 17/03

Work Order ID 57012

March 16, 2010 3:19:09 PM

Item ID: D350-591-213 **Accept** **Setup** **Start**

Revision ID: **Stop**

Item Name: Heli-Access-Step, Short LH

Start Date: 3/16/10 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 3/17/10 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** W **Date:** **Tooling:** **Date:** **Run** **Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3078	A
DSI 9472	A

100 — DC — Document Control

DOCUMENT CONTROL — 0.00

Memo — 0.00

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003 — S 10/03/17

110 — Large Fab — Large Fab

Large Fab — 0.00

Memo — 0.00

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

[signature] 10.03.16 1 Ø

Work Order ID 57012

March 16, 2010 3:19:10 PM

Item ID: D350-591-213 **Accept**

Setup **Start** / **Stop**

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 3/16/10 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 3/17/10 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run **Start** / **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	**Memo**	0.00				1	PD 10.03.16		
130	Large Fab	0.00							
Large Fab Large Fab	**Memo** 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R Aluminum Rod m11311 3-Grind End Plate flush m110130	0.00	10.03.16			1	∅		
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	**Memo**	0.00				①	PD 10.03.16		

Work Order ID 57012

March 16, 2010 3:19:14 PM

Item ID: D350-591-213
Revision ID:
Item Name: Heli-Access-Step, Short LH

Accept

Setup **Start** / **Stop**

Start Date: 3/16/10 **Start Qty:** 1.00
Required Date: 3/17/10 **Req'd Qty:** 1.00
Reference:

Cust Item ID:
Customer:

Run **Start** / **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	S 10/03/17			H 2H			
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00	10.03.17			1	Ø		
170 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00	7 M. h 10/03/17		(1K)				

Work Order ID 57012

March 16, 2010 3:19:16 PM

Item ID: D350-591-213 **Accept**

Revision ID:

Item Name: Heli-Access-Step, Short LH

Setup **Start** **Stop**

Start Date: 3/16/10 **Start Qty:** 1.00

Required Date: 3/17/10 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Large Fab Large Fab	Large Fab **Memo** Rivet Leg Assembly as per Dwg D3078.	0.00 0.00	10.03.17			1	∅		
190 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo** N/A 10.03.17	0.00 0.00							
200 Large Fab Large Fab	Large Fab **Memo** 1-Bevel Aft end for welding 2-Inspect for foreign object as per QSI 024 3-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod M11 31 4-Grind End Plate flush	0.00 0.00	10-03-17			1	∅		

Work Order ID 57012

March 16, 2010 3:19:20 PM

Item ID: D350-591-213 **Accept**

Setup Start

Stop

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 3/16/10 **Start Qty:** 1.00

Required Date: 3/17/10 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00				x1	0		BE 10/03/17
	Memo	0.00							
220 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00	8 10/03/17			① LH			
230 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00	BK 10-3-17			① LH.			

Work Order ID 57012

March 16, 2010 3:19:20 PM

Item ID: D350-591-213 **Accept**

Setup Start / Stop

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 3/16/10 **Start Qty:** 1.00

Required Date: 3/17/10 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M113170	0.00							
	Memo START TIME: 11:00AM OVEN TEMPERATURE: 320°F FINISH TIME: 11:30AM	0.00	=> JM 10/03/17			X1	Ø		
250 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M113462	0.00	BR 10-3-17			1	Ø.		
	Memo	0.00							
260 QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00	S 10/03/17			+1 WH			

Work Order ID 57012

March 16, 2010 3:19:26 PM

Item ID: D350-591-213 **Accept**

Revision ID:

Item Name: Heli-Access-Step, Short LH

Setup Start / Stop

Start Date: 3/16/10 **Start Qty:** 1.00

Required Date: 3/17/10 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start / Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 Packaging Packaging	Pick Kit	0.00					Cu 6/3/17		
	Memo	0.00							
280 QC Quality Control	QC4- 100% Inspect kits for completeness	0.00 S 10/03/17				x1 LH			
	Memo	0.00							
290 Packaging Packaging	Packaging	0.00					Cu 6/3/17		
	Memo Identify and pack for shipping as per PPP D350-591-213 Location: ______ PPP Rev: R	0.00							

Work Order ID 57012

March 16, 2010 3:19:26 PM

Item ID: D350-591-213 **Accept**

Revision ID:

Item Name: Heli-Access-Step, Short LH

Setup **Start** / **Stop**

Start Date: 3/16/10 **Start Qty:** 1.00

Required Date: 3/17/10 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** / **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC21- Final Inspection - Work Order Release	0.00						10/03/17	
QC Quality Control	**Memo**	0.00							

MF
10-3-17

Picklist Print

March 16, 2010 3:18:58 PM

8

Work Order ID: 57012

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 3/16/10 **Required Date:** 3/17/10

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2622-120C Step Extrusion		Manufactured	No			110	Each	121.2400	0.5000		10.03.16	
D3067-1 End Plate		Manufactured	No			130	Each	13.0000	1.0000		10.03.16	
D3063-1 Support		Manufactured	No			130	Each	22.0000	1.0000		10.03.16	

D2622-120C locations:

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
WA	121.24		
48612	3.12		
52026	5.12		
55214	113		1

D3067-1 locations:

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST	13		
53784	13		1

D3063-1 locations:

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST	22		
51237	22		1

Picklist Print

March 16, 2010 3:18:58 PM

Work Order ID: 57012

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 3/16/10 **Required Date:** 3/17/10

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS20600-AD4W4 Rivets		Purchased	No			180	Each	1,383.000	16.0000		10.03.17	

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST321	1383		
110731	215		
111359	46		
111477	74		
112314	85		
112385	24		
113368	439		16
114181	500		

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3066-1 Spacer		Manufactured	No			180	Each	117.0000	2.0000		10.03.17	

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST	12		
51545	11		
53783	1		
Main Warehouse			
WA	105		
56752	105		2

Picklist Print

March 16, 2010 3:18:58 PM

Work Order ID: 57012

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 3/16/10 **Required Date:** 3/17/10

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3065-041 Step Leg Assembly Hi		Manufactured	No			180	Each	45.0000	1.0000		10·03·17	
D3067-1 End Plate		Manufactured	No			200	Each	13.0000	1.0000		10·03·17	
AN3-35A Bolt		Purchased	No			270	Each	177.0000	2.0000		10/3/17	

D3065-041:

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
WA	45		
53795	15		1
55450	30		

D3067-1:

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST	13		
53784	13		1

AN3-35A:

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST353	177		
106993	12		
110467	1		
112314	164		M/12314

Picklist Print

March 16, 2010 3:19:00 PM

Work Order ID: 57012

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 3/16/10 **Required Date:** 3/17/10

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2230-1 Lug		Manufactured	No			270	Each	103.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST476	103		
51761	4		
54755	99		54755

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L3 Nut		Purchased	No			270	Each	2,238.000	2.0000			

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST300	2238		
110844	35		
111274	27		
111668	58		
112314	285		
112385	113		M112385
113523	20		
113537	700		
113644	1000		

Picklist Print

March 16, 2010 3:19:01 PM

Work Order ID: 57012

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 3/16/10 **Required Date:** 3/17/10

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Component Item ID/	Replacement	Mfg/ Purchased	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4-13A Bolt		Purchased	No			270	Each	260.0000	4.0000			
D2732 Rubber Extrusion		Manufactured	No			270	f	543.3510	1.0526			

AN4-13A locations:

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST357	260	
113749	110	
114108	50	
114181	100	

m113749

D2732 locations:

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST412	543.351	
38509	20.62	
43118	22.731	
56516	500	

43118

7 measured 8/10/3/17

cut qty of 4 at 3.00" as per dwg(D2732-030)

Picklist Print

March 16, 2010 3:19:01 PM

Work Order ID: 57012

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 3/16/10
Start Qty: 1.00
Required Date: 3/17/10
Required Qty: 1.00

Component Item ID/	Replacement	Mfg/ Manufactured	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
8 D2230-3 Lug			No			270	Each	136.0000	2.0000	✓		
5 AN960JD10 N00114900 3635 Washer		Purchased	No			270	Each	0.0000	4.0000	✓ M11328		
5 MS21042L4 Nut		Purchased	No			270	Each	2,336.000	6.0000	✓	1/3/12	

D2230-3 Warehouse locations:

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST476	136		
50306	5		
51568	2		
55310	129		55310

MS21042L4 Warehouse locations:

Warehouse Location	Loc Qty	Loc Code	Qty
Main Warehouse			
ST300	2336		
102552	6		
104248	6		
110507	184		
111827	170		M111827
113422	970		
114108	1000		

Picklist Print

March 16, 2010 3:19:02 PM

Work Order ID: 57012

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 3/16/10 **Required Date:** 3/17/10

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4-16A Bolt		Purchased	No			270	Each	148.0000	4.0000		10/3/17	

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST358	148	
112969	46	M112969
114129	100	
18949	2	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3078 — REV. A — SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT — SCALE NTS
A	02.09.11	NEW ISSUE

DART

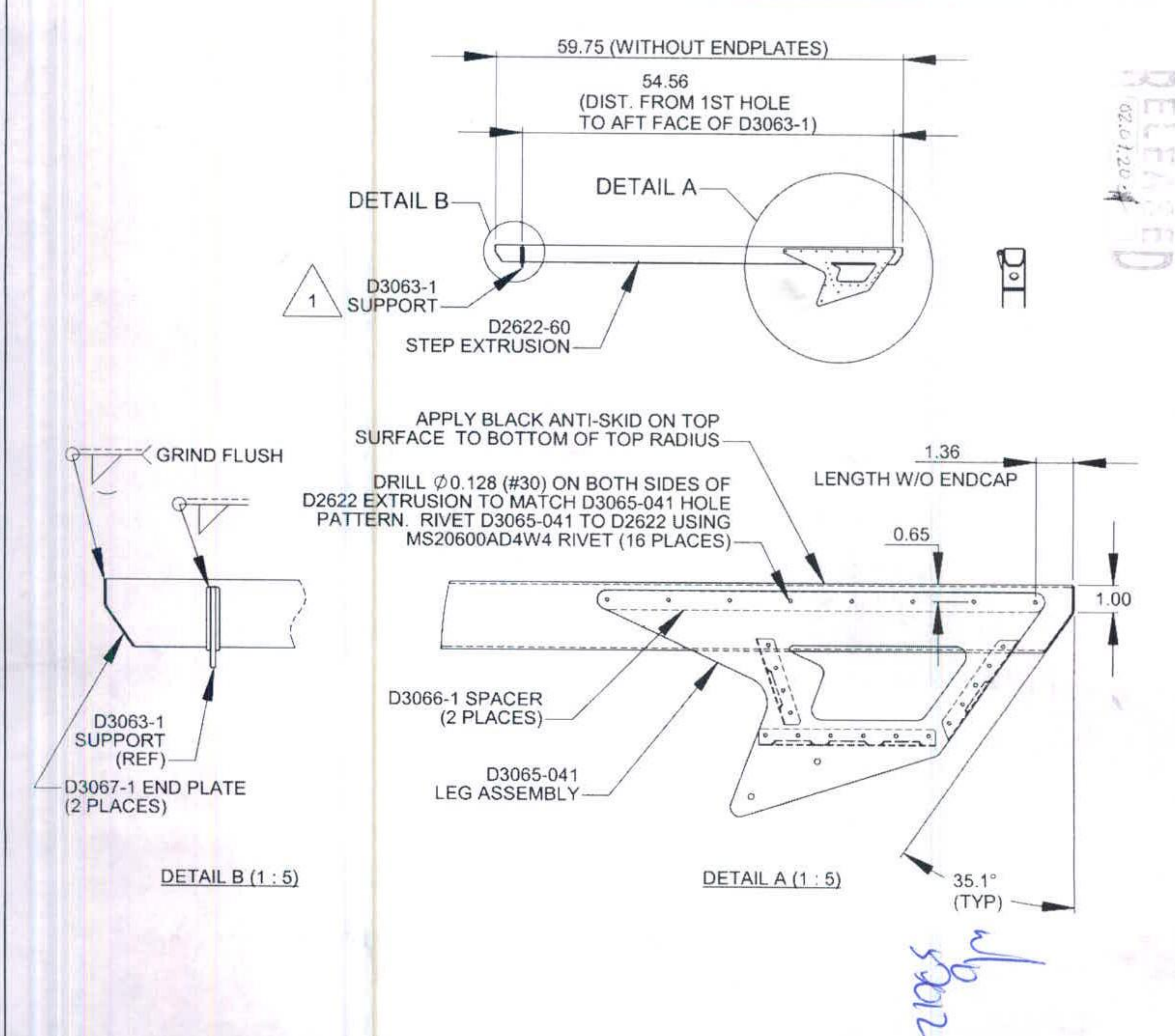
QA COPY ISSUED

RELEASED 02.01.20

Part No.	Description	QTY -041	QTY -042
D3078-041	**Step Assembly, High Short (LH)**	**X**	
D3078-042	**Step Assembly, High Short (RH)**		**X**
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

1) –041 SHOWN, FOR –042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



DART

QA COPY ISSUED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY
CHECKED	APPROVED
DATE 02.09.11	

DRAWING NO. D3078 — REV. A — SHEET 2 OF 2

TITLE STEP ASSEMBLY, HI SHORT — SCALE 1:20

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	***Heli-Access-Step***™, Long Step – High Skid, LH
	X							D350-591-212	***Heli-Access-Step***™, Long Step – High Skid, RH
		X						D350-591-213	***Heli-Access-Step***™, Short Step – High Skid, LH
			X					D350-591-214	***Heli-Access-Step***™, Short Step – High Skid, RH
				X				D350-591-215	***Heli-Access-Step***™, Short Step – Low Skid, LH
					X			D350-591-216	***Heli-Access-Step***™, Short Step – Low Skid, RH
						X		D350-591-311	***Heli-Access-Step***™, Long Step – High Skid, LH
							X	D350-591-312	***Heli-Access-Step***™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

)SI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is ·ovided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-91-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: ______________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	***Heli-Access-Step*** ™, Short Step – High Skid, LH
	X			D350-591-214	***Heli-Access-Step*** ™, Short Step – High Skid, RH
		X		D350-591-215	***Heli-Access-Step*** ™, Short Step – Low Skid, LH
			X	D350-591-216	***Heli-Access-Step*** ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01
APPROVED
BY: [signature]
D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE

DESIGN	[initials]	**DART AEROSPACE LTD** **HAWKESBURY, ONTARIO, CANADA**	
DRAWN	RF		
CHECKED	[initials]	DRAWING NO.	REV. A
MFG. APPR.	[initials]	DSI 9472	SHEET 1 OF 2
APPROVED	[signature]	TITLE	SCALE
DE APPR.	[signature]	BOLT ADDITION	NTS
DATE	09.08.05		

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE